

the handle *D*. To turn the spindle, it is merely necessary to withdraw the spring-supported locking bolt seen at the right-hand side of the base, by means of the small lever provided for that purpose, and move the index plate around by means of the handle *D* which passes through an elongated slot.

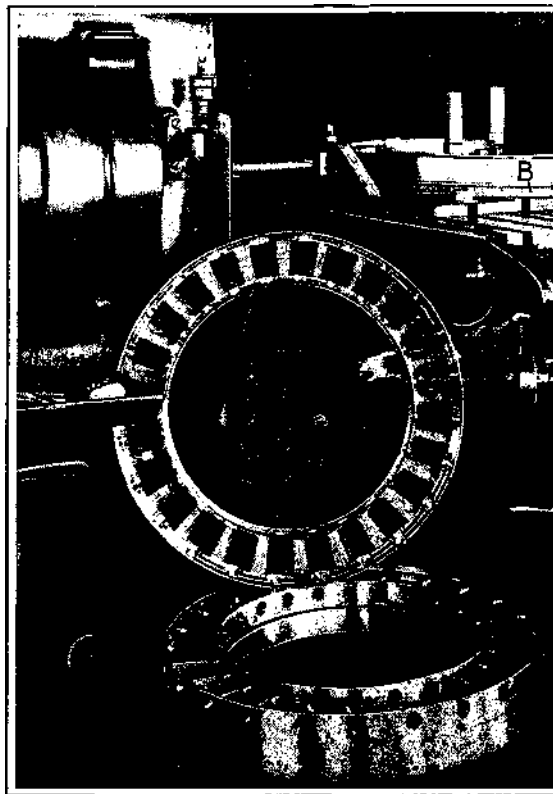


Fig. 13. Fixture for Drilling, Reaming, and Counterboring Holes in Roller Bearing Separator Rings

The method of chucking the pinion shaft *G* is clearly shown and will need little description to make it clear to any mechanic. It will be seen that a small collar *H* rests in a hole at the bottom of the spindle; this collar receives the downward thrust of the work and also serves the purpose of locating the lower end of the work to bring it exactly perpendicular. In

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